

Date: Tuesday, 8/1/2006 11:39:16 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET BASE ASSEMBLY  
 Job Number : 28043B  
 Estimate Number : 10852  
 P.O. Number : N/A Part Number : D3324041  
 This Issue : 8/1/2006 S.O. No. : N/A Drawing Number : D3324 UNDER REVIEW  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : B  
 Previous Run : 27859B Material : N/A  
 Due Date : 8/15/2006 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: A 05.02.09 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D33283 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3328-3 Hinge Plate B23727

PD 06-08-28 (1)

2.0 D33481 Clevis



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3348-1 Clevis B24713 -> 1  
 B23109 -> 3

PD 06-08-28 (1)

3.0 D33493 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3349-3 Spacer Bushing B23158

PD 06-08-28 (1)

4.0 D33671 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3367-1 Mounting Bracket B28066

PD 06-08-28 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 8/1/2006 11:39:16 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 28043B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M4130NTS0500W035

4130 Square tube .5 x .5



Comment: Qty.: 48.9300 f(s)/Unit Total : 48.9300 f(s)  
Material: 4130 Cond. N Square tube per MIL-T-6736,  
1/2" x 0.035" wall  
M4130N-TS0.500W.035)

PD 06-08-30 (1)

6.0

M569EX05018F

569 Expanded Metal



Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s)  
Pick:

Qty Part Number Description

Batch

28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel

M101927

PD 06-08-30 (1)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	M17679
4	D3324-3	Full Length Tube	M17679
2	D3324-5	Top End Tube	M17679
2	D3324-7	Bottom EndTube	M17679
10	D3324-9	Vertical Tube	M17679

Identify parts appropriately

2-Remove all markings from material & check for foreign objects

3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B

AVR/A Steel Rod M100075  
4130 rod

4-Deburr as required

PD 06-08-30 (1)

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

M 06/08/30 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/09/14

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 8/1/2006 11:39:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 28043B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/08/30 (1)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 06/09/12 (1)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G&A

MF 06/09/12 (1)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/09/14

Job Completion



W 06/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

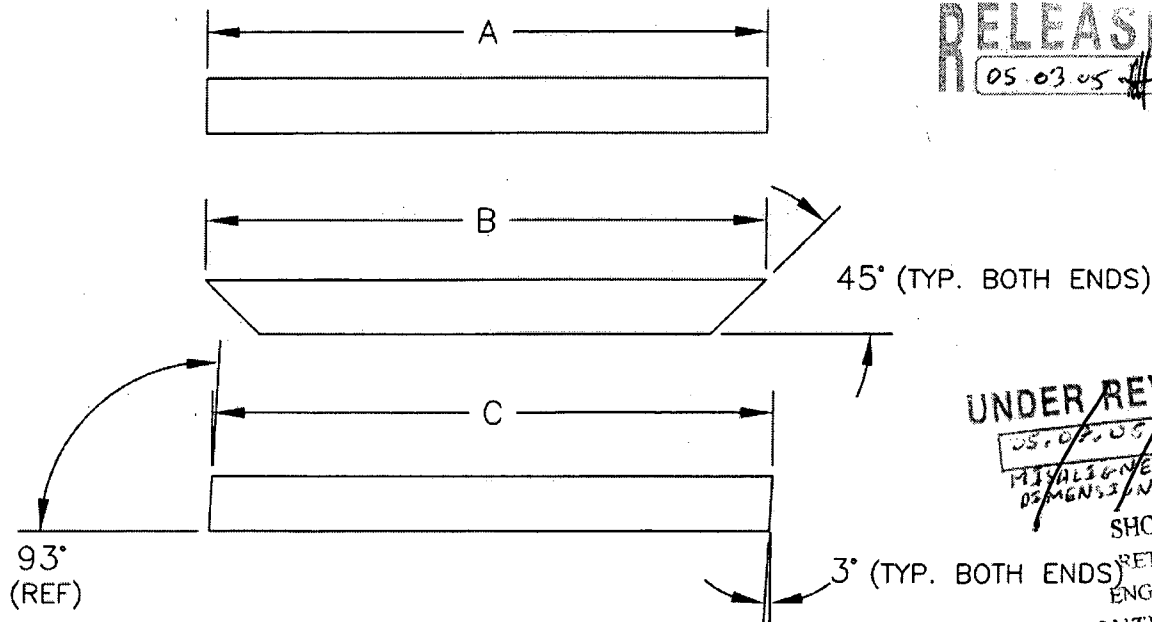
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 W.T. (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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05.03.05

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05.03.05 PH  
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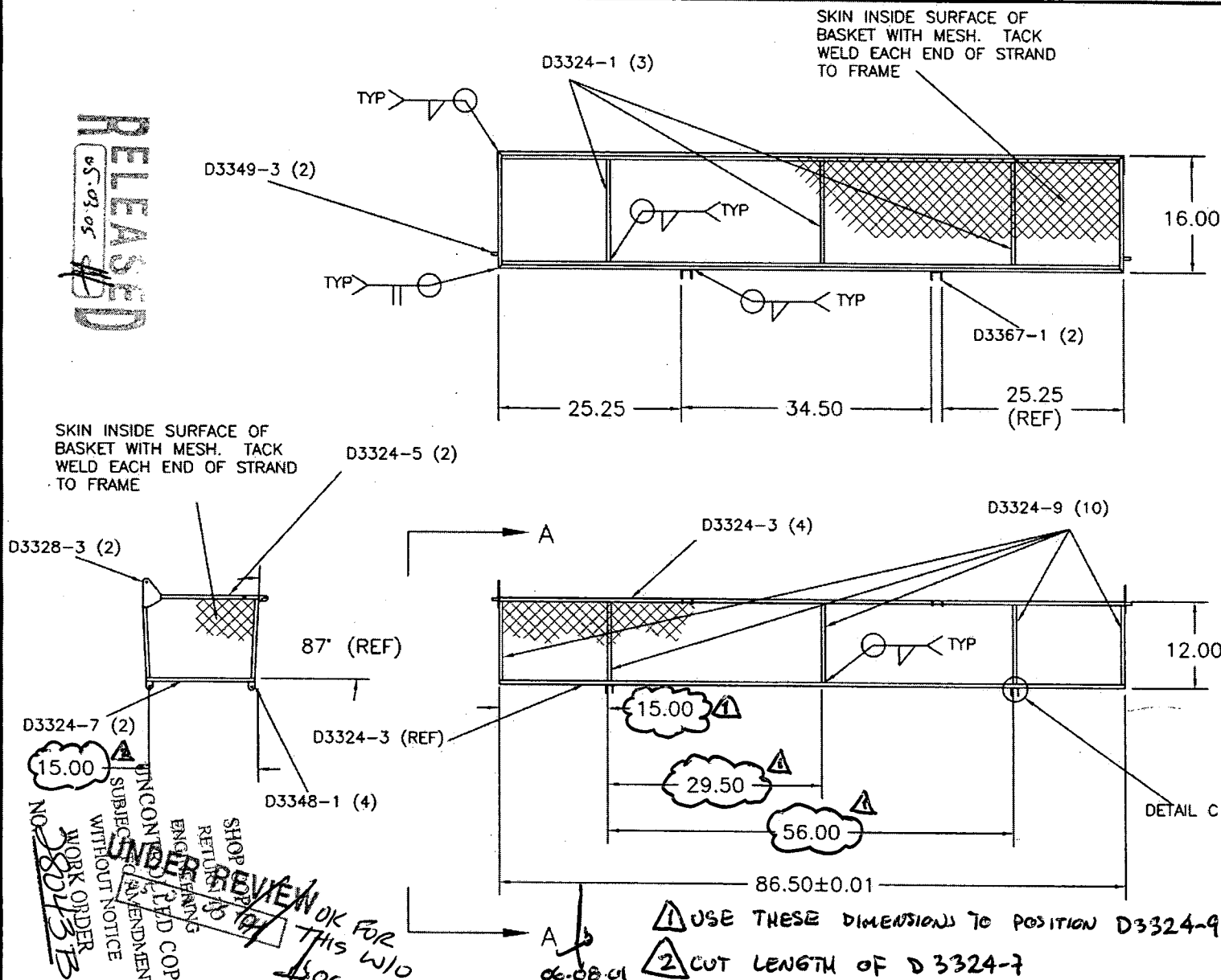
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.03.04	D3324	SHEET 2 OF 3
	TITLE	SCALE
	BASKET BASE ASSEMBLY	1:20

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05.03.05

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D3324-041 BASKET BASE ASSEMBLY

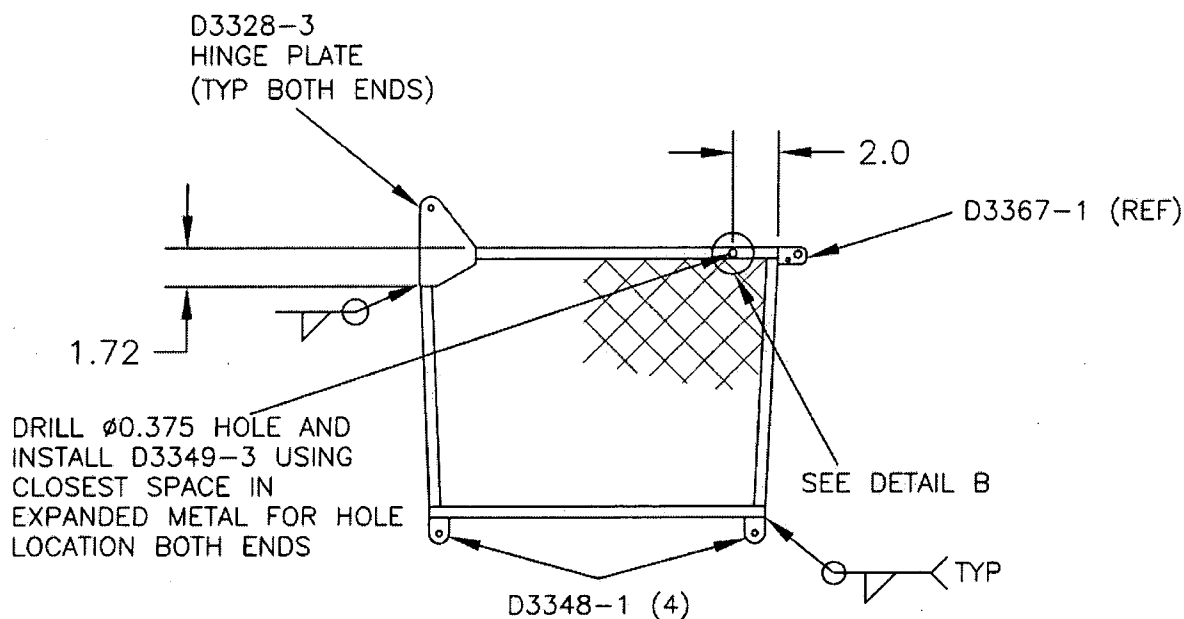
- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

UNDER REVIEW  
SHOP OK FOR THIS W/O  
06.08.01  
NO. 280453  
WORK ORDER  
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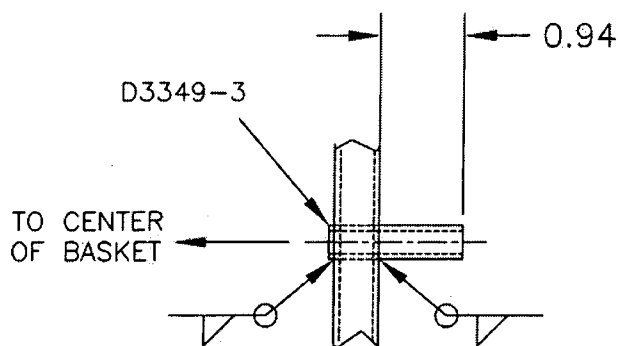


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8

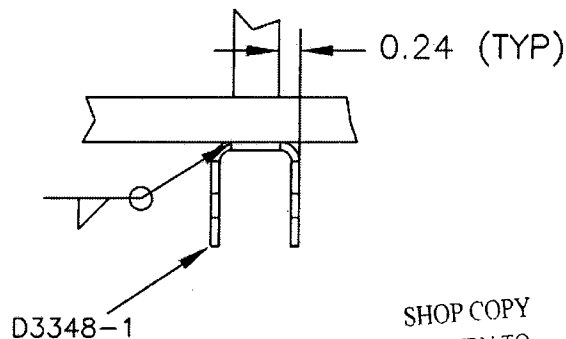


VIEW A-A

RELEASED  
05.03.05



DETAIL B  
(SCALE 1:2)



DETAIL C  
(SCALE 1:2)

UNDER REVIEW  
05.07.06 PH

OK FOR THIS w/o  
10.06.06.01

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